

APR 23 1998



U.S. Department
of Transportation

Research and
Special Programs
Administration

400 Seventh Street, S.W.
Washington, D.C. 20590

DOT-E 10865
(FIRST REVISION)

EXPIRATION DATE: March 31, 2000

(FOR RENEWAL, SEE 49 CFR 107.109)

1. GRANTEE: Robert Gas Cylinder Company, Inc.
Carolina, Puerto Rico
2. PURPOSE AND LIMITATIONS:

This exemption authorizes the rebuilding and selling of DOT Specification 4B, 4BA and 4BW cylinders in accordance with the procedures prescribed within this exemption, for use in the transportation of hazardous materials authorized in paragraph 6. This exemption provides no relief from any regulation other than as specifically stated herein.
3. REGULATORY SYSTEM AFFECTED: 49 CFR Parts 106, 107 and 171-180.
4. REGULATIONS FROM WHICH EXEMPTED: 49 CFR 173.34(1) subparagraphs 1, 2, and 3.
5. BASIS: This exemption is based on the application of Robert Gas Cylinder Company, Inc. dated February 12, 1998, submitted in accordance with 49 CFR 107.109.
6. HAZARDOUS MATERIALS (49 CFR 172.101):

Hazardous materials description -- proper shipping name	Hazard Class/ Division	Identi- fication Number	Packing Group
Compressed gases, flammable liquids, corrosive materials and other hazardous material that are authorized to be shipped in DOT 4B, 4BA, and 4BW cylinders of 49 CFR Part 173.	As appropriate	As appropriate	As appropriate

APR 23 1998

Continuation of DOT-E 10865 (1st Rev.)

Page 2

7. PACKAGING(S) and SAFETY CONTROL MEASURES:

This exemption authorizes the rebuilding and selling of low-pressure, DOT Specification 4B, 4BA and 4BW steel cylinders having water capacities not exceeding 1000 pounds, in accordance with the following:

a. Only cylinders originally manufactured to a DOT Specification 4B, 4BA and 4BW may be rebuilt and represented as DOT 4B, 4BA or 4BW cylinders.

b. Rebuilding work must be performed in accordance with the approved Procedures Manual on file in the Office of Hazardous Materials Exemptions and Approvals and Section 173.34(1).

c. Rebuilder shall be considered a manufacturer subject to the requirements of Section 178.2(a)(2) and Subpart C of Part 178.

d. After removal of a non-pressure component and before replacement of any non-pressure component, the cylinder must be visually inspected in accordance with the requirements of CGA Pamphlet C-6. Rejected cylinders must be repaired and rebuilt as prescribed in 49 CFR 173.34(i) or (j), or condemned.

e. Rebuilding of any cylinder involving a joint subject to internal pressure may only be performed by fusion welding. The rebuilder may rebuild a DOT 4B, 4BA or 4BW cylinder having a water capacity of 20 pounds or greater by replacing a head of the cylinder using a circumferential joint. When this weld joint is located at other than an original welded joint, a notation of this modification must be shown on the Manufacturer's Report of Rebuilding (see Appendix A). Weld joint must be on the cylindrical section of the cylinder.

f. Welding must be:

i. Performed in accordance with the procedures and qualification requirements of CGA Pamphlet C-3.

ii. Performed using welding rods compatible with the material of the cylinder including any non-pressure component.

iii. Performed on an area free of any contaminant.

APR 23 1998

Continuation of DOT-E 10865 (1st Rev.)

Page 3

g. Each rebuilt cylinder must be:

i. Heat treated as required in the applicable specification.

ii. Subjected to a full hydrostatic volumetric expansion test on each cylinder as specified in the applicable cylinder specification in Part 178. The results of the tests must conform to the requirements of the applicable cylinder specification.

iii. Inspected and have test data reviewed to determine conformance with the applicable cylinder specification.

iv. Made of material in conformance with the specification. Determination of conformance shall include chemical analysis, verification, inspection and tensile testing of the replaced part. Tensile tests must be performed by lots defined in the applicable specification.

h. A record of rebuilding, in the format presented in Appendix A, must be completed for each rebuilt cylinder.

i. A copy of the reports of rebuilding must be maintained by the rebuilding facility for at least 15 years.

8. SPECIAL PROVISIONS:

a. Each packaging rebuilt under the authority of this exemption and in accordance with an approval issued under Section 173.34(1), must be marked with the approval number issued to the holder of this exemption.

b. A current copy of this exemption, in addition to the referenced approval document in 8a., must be maintained at the facility where the cylinders are rebuilt and must be made available to the DOT representative upon request.

9. MODES OF TRANSPORTATION AUTHORIZED: Motor vehicle, rail freight, cargo vessel, cargo aircraft only, and passenger aircraft.

APR 23 1998

10. MODAL REQUIREMENTS: A copy of this exemption must be carried aboard each cargo vessel, aircraft or motor vehicle used to transport packages covered by this exemption. The shipper shall furnish a copy of this exemption to the air carrier before or at the time the shipment is tendered.
11. COMPLIANCE: Failure by a person to comply with any of the following may result in suspension or revocation of this exemption and penalties prescribed by the Federal hazardous materials transportation law, 49 U.S.C. Section 5101 et seq:
- o All terms and conditions prescribed in this exemption and the Hazardous Materials Regulations, Parts 171-180.
 - o Registration required by 49 CFR 107.601 et seq., when applicable.

Each "Hazmat employee", as defined in 49 CFR 171.8, who performs a function subject to this exemption must receive training on the requirements and conditions of this exemption in addition to the training required by 49 CFR 172.700 through 172.704.

No person may use or apply this exemption, including display of its number, when the exemption has expired or is otherwise no longer in effect.

12. REPORTING REQUIREMENTS: The carrier is required to report any incident involving loss of packaging contents or packaging failure to the Associate Administrator for Hazardous Materials Safety (AAHMS) as soon as practicable. (49 CFR 171.15 and 171.16 apply to any activity undertaken under the authority of this exemption.) In addition, the holder(s) of this exemption must also inform the AAHMS, in writing, as soon as practicable of any incidents involving the package and shipments made under this exemption.

Issued at Washington, D.C.

Ayan I. Roberts
Ayan I. Roberts
Associate Administrator
for Hazardous Materials Safety

4/23/98
(DATE)

APR 23 1998

Continuation of DOT-E 10865 (1st Rev.)

Page 5

Address all inquiries to: Associate Administrator for Hazardous Materials Safety, Research and Special Programs Administration, Department of Transportation, Washington, D.C. 20590.
Attention: DHM-31.

The original of this exemption is on file at the above office. Photo reproductions and legible reductions of this exemption are permitted. Any alteration of this exemption is prohibited.

Dist: USCG, FAA, FHWA, FRA
PO: ALB

APPENDIX A
Manufacturer's Report of Rebuilding

Cylinder Identification

Manufacturer _____
Cylinder Specification Number and Service Pressure _____
Cylinder Serial Number _____
Date of Original Manufacture _____
Other Identification Marks _____

Rebuild Information

Chemical Analysis of Replacement Parts

Parts Being Replaced _____
Heat Identification _____
Steel Manufactured by _____
Analysis Performed by _____

C	P	S	Si	Mn	Ni	Cr	Mo	Cu	Al	Zr
_____	_____	_____	_____	_____	_____	_____	_____	_____	_____	_____

Record of Physical Test of Replacement Parts

Yield PSI	Tensile PSI	Elongation in _____inches	Reduction of Area %	Weld Tensile	Weld bend
_____	_____	_____	_____	_____	_____

Record of Hydrostatic Test

Calculated Volumetric Capacity of Cylinder Being Rebuilt

Actual Test Pressure	Total Expansion	Permanent Expansion	% of Total to Perman.	Volumetric Capacity
_____	_____	_____	_____	_____

(Volumetric capacity of rebuilt cylinder must be + or - 3% of the calculated capacity)

I certify that this rebuilt cylinder is accurately represented by the data above and that all provisions of DOT-E 10865 and other applicable regulations have been complied with.

Repair Technician _____ Date _____

Company Representative _____ Date _____